

WHAT IS CLAIMED:

- 1) A gusseted bag comprising a tubular sleeve having an open top, a closed bottom, a pair of opposing front faces and a pair of opposing side walls, with gussets connecting said frontal faces, said bag
5 being unitarily formed with at least one additional seal on each top edge of the bag, sealing the gusset members through and through on each side of the bag.
- 2) The bag according to Claim 1 having at least one one block seal on each side of the bag.
- 10 3) The bag according to Claim 1 having at least one diagonal seal on each side of the bag.
- 4) The bag according to Claim 1 having at least one longitudinal seal on each side of the above.
- 15 5) The bag according to Claim 1 having smaller reduced gusset sides on both sides of bag.
- 6) The bag according to Claim 1 having a zipper closure or other closure device and a cut-out handle.
- 7) The bag according to Claim 1 having slit near
20 top of body of bag and below zipper closure to vent air out of bag.

8) The bag according to Claim 1 having block seal on zipper closure to restrict zipper closure from passing sealed portion of gussets on both sides of bag.

5 9) The method of making a gusseted bag comprising of steps of forming at least one additional seal on top edge of the gusseted portion of bag sealing the gussets through and through the film.

10 10) The method according to Claim 9 including at least one long longitudinal seal sealing all gussets to reinforce top seals and top closures.

15 11) The method according to Claim 9 including at least one diagonal seal sealing all gusset film to reinforce the closure and making for easy discharge of the contents.

12) The method according to Claim 9 including block sealed area directly below the top of sealed gussets.

20 13) The method according to Claim 9 including at least one or more small sized or reduced size gussets on each side of bag to allow for easy discharge of contents without compromising the integrity, shape and characteristic of the gusseted "square bottom"

bag or regular gusseted bag.

14) The method according to Claim 9 including at least one additional seal on top edge of bag, sealing gussets through the film material.

5 15) The method according to Claim 9 including gusseted plastic bag with zipper closure or other closure device.

16) The method according to Claim 9 including a cut-out handle over a zipper closure on a gusseted bag.

10 17) The method according to Claim 9 including a slit or small opening near the top of body of bag and below zipper closure.

15 18) The method according to claim 9 including the step of block sealing and reducing the overall size of the zipper closure for uniformity with the sealed gusseted side so zipper closure does not extend past the sealed gusseted sides.